

Date: Tuesday, 08/01/2008 8:35:38 AM
 User: Dominique Dube

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.		Drawing Name	: PB67-43001-325		
Job Number	: 36656		Part Number	: PB6743001325		
Estimate Number	: 10804		Drawing Number	: PB6743001325		
P.O. Number	:		Project Number	:		
This Issue	: 08/01/2008	S.O. No. :	Drawing Revision	:		
Prsht Rev.	: NC		Material	:		
First Issue	: / /	Type : LARGE FAB ASSY	Due Date	: 15/01/2008	Qty:	1 Um: Each
Previous Run	: 36349					
Written By	:					
Checked & Approved By	:					
Comment	:					

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL		
ISSUE TRAVELER		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET		
CUT B67-43001-325 AS PER DWG 17.65" X 2.50" 0.032" THK 2024T3 <i>B 166272 HB 8-1-8</i>		
DE-BURR <i>HB 8-1-8</i>		
3.0	M2024T3S032	2024-T3 .032 sheet <i>HB 8-1-8</i>
Comment: Qty.: 0.3200 sf(s)/Unit Total : 0.3200 sf(s) 2024T3 0.032 Sheet		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE <i>HB -8-1-8</i>
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	QC8	SECOND CHECK <i>HB 08/01/08 (2)</i>
Comment: SECOND CHECK		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Seq. #: Machine Or Operation:

Description :

6.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

DRILL #40 FOR MS21075L3 NUT PLATE AND COUNTERSINK RIVET HOLES AS PER DWG
B67-43001-325

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

CHEMICAL CONVERSION COAT AS PER QSI005 4.1 (ALODINE)

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE-1

INSTALL MS21075L3 NUT PLATES USING MS20426AD3-4 RIVETS
AS PER DWG B67-43001-325

11.0 MS21075L3

Nutplate



Comment: Qty.: 5.0000 Each(s)/Unit Total : 5.0000 Each(s)
Nutplate

08-01-08

m106576

mf

12.0 MS20426AD34

RIVET



Comment: Qty.: 10.0000 Each(s)/Unit Total : 10.0000 Each(s)
RIVET

m102404 mf 08-01-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.	Drawing Name: PB67-43001-325
Job Number: 36656	Part Number: PB6743001325
Job Number:	
Seq. #: 13.0	Machine Or Operation: QC5
	Description : INSPECT WORK TO CURRENT STEP
Comment: INSPECT WORK TO CURRENT STEP	 <i>d o s o l o g (t)</i>
14.0	HAND FINISHING1
	Description : HAND FINISHING RESOURCE #1
	 <i>M 102316</i>
Comment: HAND FINISHING RESOURCE #1	 <i>(LK)</i>
	POWDER COAT GREEN SANDTEX AS PER QSI005 4.3 (4.35.8)
15.0	QC3
	Description : INSPECT POWDER COAT/CHEMICAL CONVERSION
	 <i>48</i>
Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION	 <i>08-01-09</i>
16.0	PACKAGING 1
	Description : PACKAGING RESOURCE #1
	 <i>1</i>
Comment: PACKAGING RESOURCE #1	 <i>11 08-01-28</i>
	IDENTIFY & PLACE IN STOCK
17.0	QC21
	Description : FINAL INSPECTION/W/O RELEASE
	 <i>11 08-01-28</i>
Comment: FINAL INSPECTION/W/O RELEASE	 <i>1</i>
Job Completion	 <i>W</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

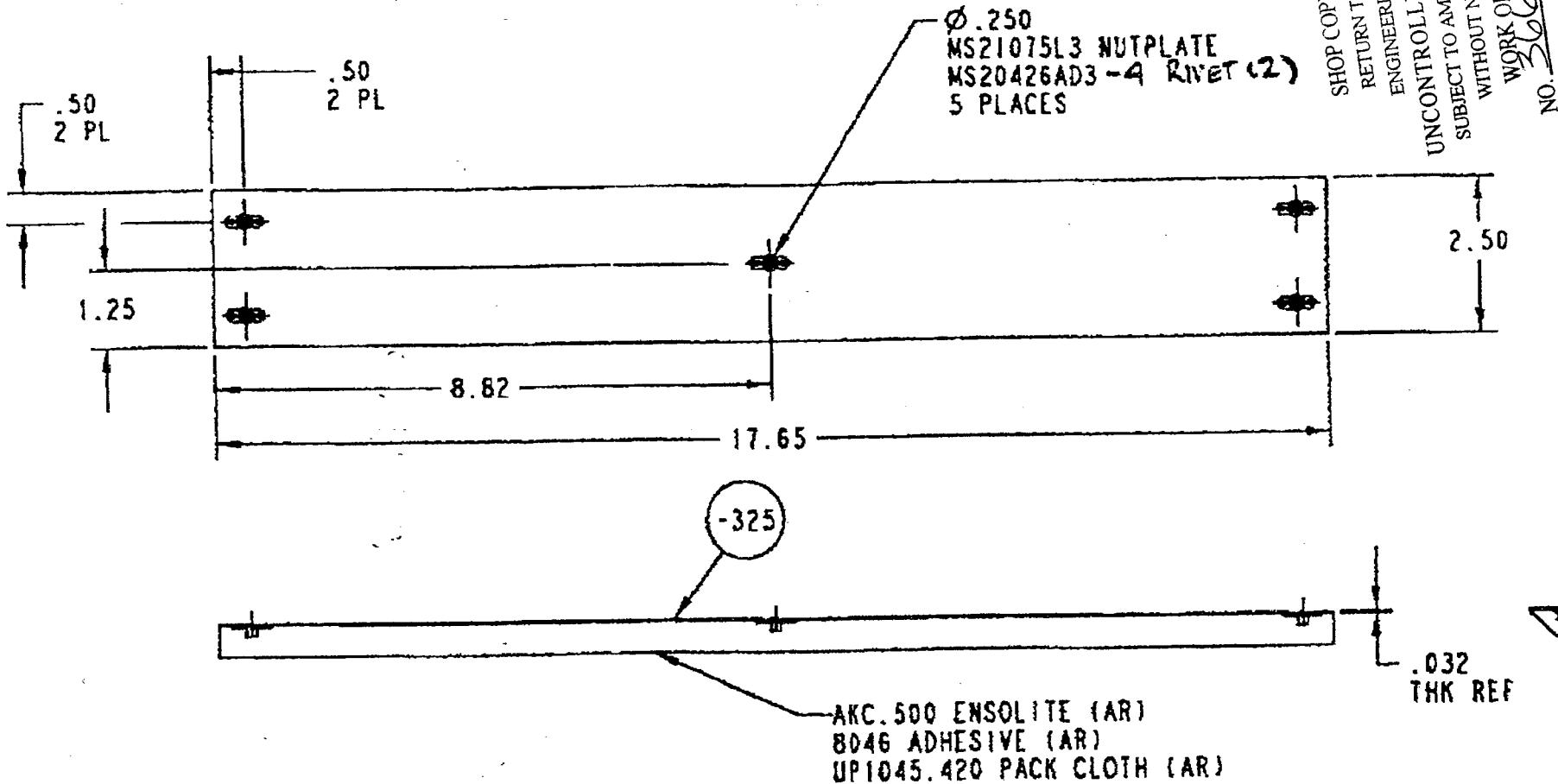
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

(1) -31 UPPER RESTRAINT WELDMENT

SCALE 0.500



(1) -33 UPPER PAD ASSY

SCALE 0.500

MATL FOR -325: .032 THK 2024-T3 AL,
QQ-A-250/4

DART AEROSPACE LTD	Work Order:	36656
Description: PB67-43001-326	Part Number:	
Inspection Dwg:	Rev:	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

First Article Prototype

Measured by:	KB	Audited by:		Prototype Approval:	n/a
Date:	8-1-88	Date:	08/01/88	Date:	g

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	